

Work Order ID 142024

Tuesday, February 23, 2016 2:24:58 PM

142024

Page 1

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 2/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: FEB 24 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS
D2273	<u>K L</u>	10
D350-604-041	C	9-89

DAS
6

MAY 30 2016

MLJ

16-05-30

100

Document Control

9-89 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-604-041
CHG009

DAS
28
9-89

JUN 01 2016

110

0.00

110

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 31489

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: FDC Composites Inc.

Certification of Conformity and process sheet required.

1

FEB 25 2016

DAS
13
9-89

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 142024***142024***

Page 2

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Start Date: 2/23/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 5/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- INSTALL DECALS AS PER DWG								

1x SP/16-05-26

① 16-05-27 PD.

DAS
28
9-89
JUN 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause	FAULT CATEGORY																																																																
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OTHER : ☐																																																																	

Work Order ID 142024

Tuesday, February 23, 2016 2:24:58 PM

142024

Page 4

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 2/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
160						DAS			
Packaging	Memo	0.00				28	DAS	JUN 01 2016	
Packaging	Identify and pack for shipping as per PPP D350-604-041					9-89	27		
	Location: <u>Fg 107</u>						9-89		
	PPP Rev: <u>Fg 107</u>								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

mcs

JUN 01 2016

dm 16/06/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Tuesday, February 23, 2016 2:25:02 PM

12

Required Qty: 1.00

12

MAY 30 2016

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 142024

142024

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 2/23/2016

Required Date: 5/11/2016

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155

Each

19.0000

1

1

D5062-041

Bracket Assembly

Location

Loc Qty

Loc Code

ST147

19

130525

14

131060

5

1

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

TABLE 1

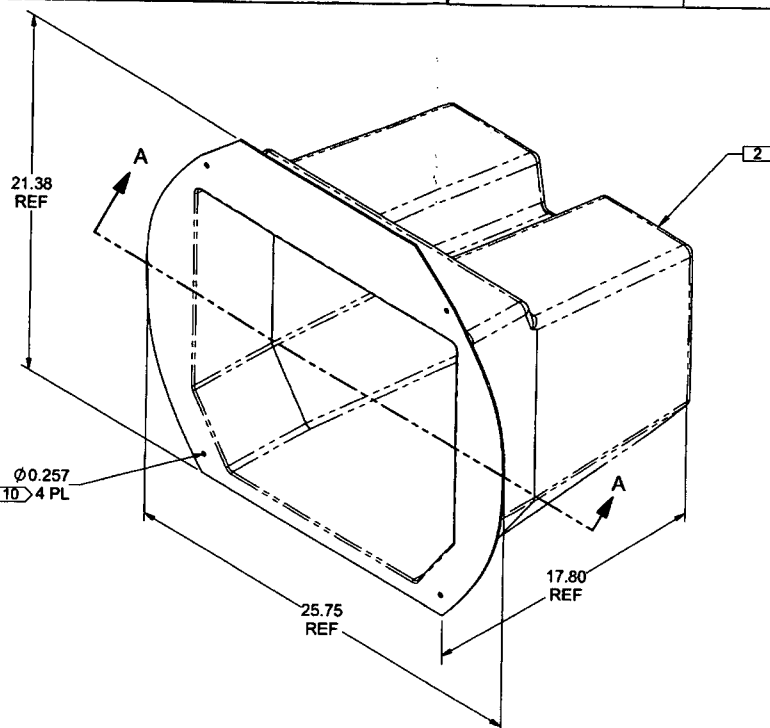
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
ACCEPTABLE TO COVER CRACKS IN GELCOAT BY APPLYING A LAYER OF PPG 6941241A 2C ACRYCOTE WHITE PAINT OVER GELCOAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5 - 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

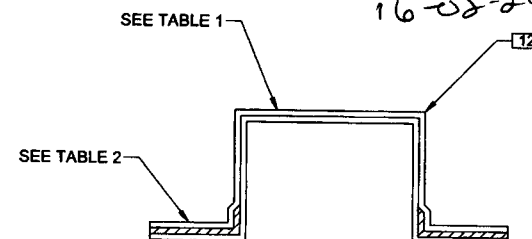
TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	POLYCOR 2330PAWK745 (WHITE)
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

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WORK ORDER

NO. 142024 MJS

16-02-24



SECTION A-A

L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MATL PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AP	DRAWING NO.	REV. L
MFG. APPR.	JLM	D2273	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	350 REAR LOCKER EXTENDER	NTS
DATE	15.10.19	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2015-11-03
EN 15-637

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31489**

Purchase Order Date 2/25/2016
PO Print Date 2/25/2016

Page Number 5 of

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26

ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-357-1344 ext303

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Journey Freight collect

Line Total:

\$835.00

13 D350-604-041P

Rear Locker Extender

5/12/2016

Yes

1.00
Each

5/12/2016

AS PER DWG.D2273 REV.L
B142022

Line Total:

\$835.00

14 D350-604-041P

Rear Locker Extender

5/12/2016

Yes

1.00
Each

5/12/2016

AS PER DWG.D2273 REV.L
B142023

Line Total:

\$835.00

15 D350-604-041P

Rear Locker Extender

5/12/2016

Yes

1.00
Each

5/12/2016

AS PER DWG.D2273 REV.L
B142024

Line Total:

\$835.00

Note:

2/25/2016

5016-05-26

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison 19/05/2016

Commande : 2408 Rev. A
Référence : PO #31489/9-20

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
	2016-03-24-3 As per DWG.D2273 Rev .L B142023			
D350-604-041P ✓	REAR LOCKER EXTENDER PO item: 31489/15 2016-03-29-1 As per DWG.D2273 Rev .L B142024	1		
D350-604-041P ✓	REAR LOCKER EXTENDER PO item: 31489/16 2016-03-29-2 As per DWG.D2273 Rev .L B142025 ✓	1 ✓		
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/17 2016-03-30-1 As per DWG.D2273 Rev .L B142026	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/18 2016-03-30-2 As per DWG.D2273 Rev .L B142027	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/19 2016-03-31-1 As per DWG.D2273 Rev .L	1		

SP/6-05-26

*** Suite autre page ***



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

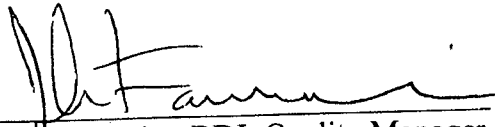
Customer P/O Number: 31489
Rev. NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
9	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142018	DAE001-074	2016-03-11
10	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142019	DAE001-075	2016-03-23-1
11	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142020	DAE001-076	2016-03-23-2
12	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142021	DAE001-077	2016-03-24-1
13	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142022	DAE001-078	2016-03-24-2
14	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142023	DAE001-079	2016-03-24-3
15	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142024	DAE001-080	2016-03-29-1
16	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142025	DAE001-081	2016-03-29-2
17	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142026	DAE001-082	2016-03-30-1
18	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142027	DAE001-083	2016-03-30-2
19	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142028	DAE001-084	2016-03-31-1
20	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142029	DAE001-085	2016-03-31-2

NOTE : Paint process : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 01516. Catalyst was PPG 794002 2C Acrycote Lot 98841.
Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds).

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Jules Fournier, BDI, Quality Manager

Date: 2016-03-31